

WORK INSTRUCTION		
Title: IV/OC Sealing Surface Finish Inspection		
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Approved for Use by: <u>Michael R. Brown</u> Effective Date: <u>July 2003</u>		
Applicable Drawings:		
<ul style="list-style-type: none"> X-106-500-SNP (Sheets 1-9) RH-TRU 72-B Packaging SARP Drawings 		
SARP Requirements:		
<ul style="list-style-type: none"> Chapter 8.0. Annually 		
Tools Required:		
<ul style="list-style-type: none"> Surface finish comparator plate Surftest 211 (finish tester, or equivalent) 		
Spare Parts Required:		
<ul style="list-style-type: none"> None 		
Materials Required:		
<ul style="list-style-type: none"> Denatured alcohol or equivalent Lint-free rags 		
Safety Requirements:		
<ul style="list-style-type: none"> Safety will be observed in accordance with site requirements. 		
Prerequisite Conditions:		
<ul style="list-style-type: none"> Lids are removed and placed on stands. 		
Instruction Steps:		
<ul style="list-style-type: none"> Record all data from this instruction on the attached data sheets. This instruction is not required to be attached to the Maintenance Record, but may be used as a checklist during performance of maintenance. 		
1.0 If not already done, remove the IV/OC main O-rings.		
NOTE: If O-rings are being changed per annual requirement, discard. If not, clean thoroughly and place in plastic bag. Label the bag with the appropriate O-ring name and unit number.		
2.0 Using alcohol and lint-free rags, thoroughly clean the grooves.		

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<p>3.0 Using the comparator plate or Surftest 211 instrument, check surface finish of the bottom of each lid seal O-ring groove at equally spaced locations and record readings on Attachment 1, Form 1.</p> <p>NOTE: If surface finish at any location exceeds 125 micro-inches, GO TO Work Instruction RH.07 for repair.</p> <p>4.0 Using the comparator plate or Surftest 211 instrument, check surface finish of the surface of the cask body O-ring sealing areas at equally spaced locations as shown on attachment and record readings on Attachment 1, Form 2.</p> <p>NOTE: If surface finish at any location exceeds 125 micro-inches, GO TO Work Instruction RH.07 for repair.</p> <p>5.0 If not replacing main O-rings as part of annual maintenance, clean and reinstall main O-rings previously placed in plastic bags in accordance with Work Instruction RH.02.</p>		
<p>Verification Requirements:</p> <p>1.0 Work performed is described on the Maintenance Record.</p> <p>2.0 Work instruction is listed on the Maintenance Record.</p> <p>3.0 Data sheets (Work Instruction RH.06, Forms 1 and 2) are attached to the Maintenance Record.</p>		

Attachment - 1, Form 1 - IV/OC Lid Bottom Surface Seal O-ring Groove Finish

Packaging S/N: _____	Date: _____	Job No.: _____
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IV LID ASSEMBLY

OC LID ASSEMBLY

IV Lid				OC Lid		
Loc.	Upper Finish	Middle Finish	Lower Finish	Loc.	Upper Finish	Lower Finish
1.				1.		
2.				2.		
3.				3.		
4.				4.		
5.				5.		
6.				6.		
7.				7.		
8.				8.		
				9.		

- If the Surface finish is greater than 125 micro inches at any location, **GO TO** Work Instruction RH.07 for repair.

Comparator or Surftest 211 S/N: _____

Calibration Due Date: _____

QA: _____

Date: _____

Attachment - 1, Form 2 - IV and OC Cask Body O-ring Sealing Surface Finish

Packaging S/N: _____	Date: _____	Job No.: _____
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ALIGNMENT PIN, 2X

IV END FORGING

ALIGNMENT PIN, 2X

IMPACT LIMITER HOLE 6X

OC END FORGING

IV Seal Flange				OC Seal Flange	
Loc.	Upper Finish	Middle Finish	Lower Finish	Loc.	Finish
1.				1.	
2.				2.	
3.				3.	
4.				4.	
5.				5.	
6.				6.	
7.				7.	
8.				8.	
				9.	

• If the Surface finish is greater than 125 micro inches at any location, **GO TO** WI-RH. 07 for repair.

Comparator or Surftest 211 S/N: _____ Calibration Due Date: _____

QA: _____ Date: _____